

Work Order ID 85237

June-05-12 9:07:21 AM

85237

Page 1

Item ID: D412-705-017

Accept

Revision ID:

Item Name: N1 Gearbox Access Panel

Start Date: 05/06/2012 Start Qty: 4.00

4

Required Date: 19/06/2012 Req'd Qty: 4.00

4

Reference:

Approvals: Process Plan: MLJ Date: 12/06/10 Tooling: Date: Run Start *NR1*
QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D3255	Rev.B
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100	DOCUMENT CONTROL	50	0.00						
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100	DC		0.00						
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Document Control	Memo		0.00						
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	Photocopy bluefile & type labels per PPPD412-705-017			CHG001	8/26/11				
--	--	--	--	--------	---------	--	--	--	--

110	Pick Kit	50	0.00						
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110	Packaging		0.00						
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Packaging	Memo		0.00						
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120	QC4- 100% Inspect kits for completeness	50	0.00						
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120	QC		0.00						
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Quality Control	Memo		0.00						
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 85237

June-05-12 9:07:21 AM

85237

Page 2

Item ID: D412-705-017

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: N1 Gearbox Access Panel

Start Date: 05/06/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 19/06/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	*NR1*
						Stop	*NR2*
	QC:	Date:	SPC (Y/N):	Date:			

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130 Packaging	Packaging								
	Memo	0.00							
	Identify and pack for shipping as per PPP D412-705-017 Location: FG 10 PPP Rev: A								
140	QC21- Final Inspection - Work Order Release	0.00							
140 QC	Memo	0.00							
	Quality Control								

*12/6/12**NR 06-01
(2-06-01)*

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

Picklist Print

June-05-12 9:07:26 AM

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Work Order ID: 85237

85237

Parent Item: D412-705-017

D412-705-017

Parent Item Name: N1 Gearbox Access Panel

Start Date: 05/06/2012

Required Date: 19/06/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:C Removed Manufacturing 06-08-02 JLM
IPP Rev:D ECN 1052 07-11-06 DD verified by: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN3C3A		Purchased		No		120	Each	237.0000	30	120	50		**

AN.3C3A

Bolt

Location	Loc Qty	Loc Code
GA	70	
118352	70	
ST350	167	
120187	1	
121185	16	
121444	75	
121723	75	

D3255-041

Access Panel Assembly

Manufactured No

D3255-042

Access Panel Assembly

Location	Loc Qty	Loc Code
ST176	4	
79168	2	
83199	2	

Manufactured No

Location	Loc Qty	Loc Code
ST176	1	
78830	1	

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

Picklist Print

June-05-12 9:07:26 AM

Page 2

Work Order ID: 85237

85237

Parent Item: D412-705-017

D412-705-017

Parent Item Name: N1 Gearbox Access Panel

Start Date: 05/06/2012

Required Date: 19/06/2012

MS20427M3-3

Purchased No

120 Each 1,601.000

36

144

**

MS20427M3-3

Rivet

MS21060-13K

Purchased No

120 Each 209.0000

18

72

**

MS21060-13K

Nut Plate

MS9321-09

Purchased No

120 Each 412.0000

30

120

**

MS9321-09

Washer

Location Loc Qty Loc Code

GA 1363

121114

ST318 238

120930

121350 38

200

200

38
108
18
72
S

Location Loc Qty Loc Code

302 100

121652

ST303 109

120142

121444 95

14

58
S

Location Loc Qty Loc Code

ST296 412

119546

120142 50

120867

121524 2

160

200

100
S

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

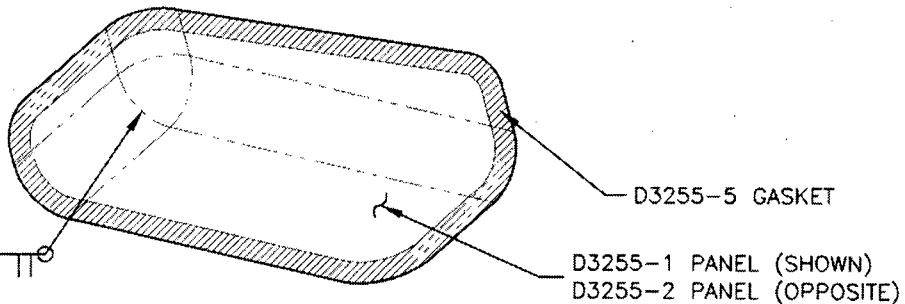
NOTE: Date & initial all entries



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. B
		D3255	SHEET 1 OF 4
DATE		TITLE	SCALE
04.12.06		ACCESS PANEL ASSEMBLY	1:6
A	04.01.27	NEW ISSUE	
B	04.12.06	D3255-3 REDESIGN; ADDED ϕ 0.098	

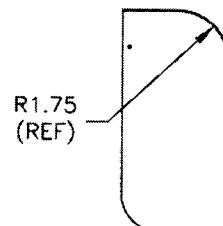
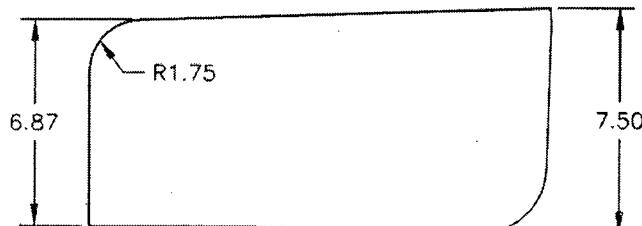
RELEASED
05.01.18

WELD D3255-3

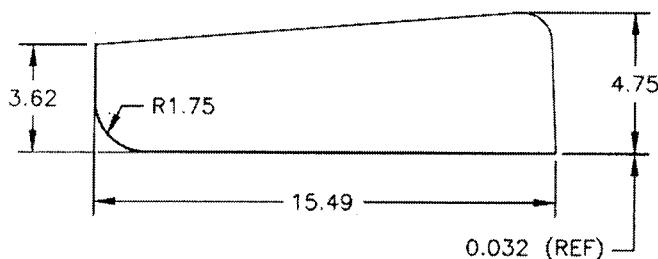


D3255-1 PANEL (SHOWN)
D3255-2 PANEL (OPPOSITE)

**D3255-041 ACCESS PANEL (SHOWN)
D3255-042 ACCESS PANEL (OPPOSITE)**



0.032 (REF)



**D3255-1 BEND DETAIL
D3255-2 OPPOSITE**

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 85237 MJS
12/06/05

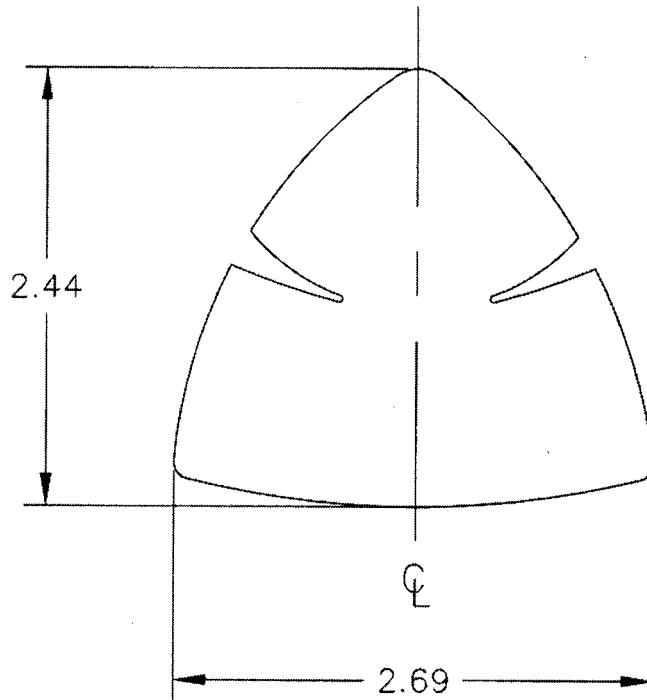
D3255-041/-042 NOTES:

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3
- 3) INSTALL D3255-5 GASKET USING DOW CORNING P/N 736 ADHESIVE IN ACCORDANCE WITH MANUFACTURE'S INSTRUCTIONS
- 4) IDENTIFY WITH P/N & B/N USING FINE POINT PERMANENT MARKER



DESIGN JF	DRAWN BY JF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED JP	APPROVED H	DRAWING NO. D3255	REV. B SHEET 2 OF 4
DATE 04.12.06		TITLE	SCALE 1:1

RELEASED
05.01.08 H



D3255-3 CAP
FORM TO FIT D3155-1/-2

D3255-3 NOTES:

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) MAKE PER DRAWING "D3255-B2.DWG"

1032250

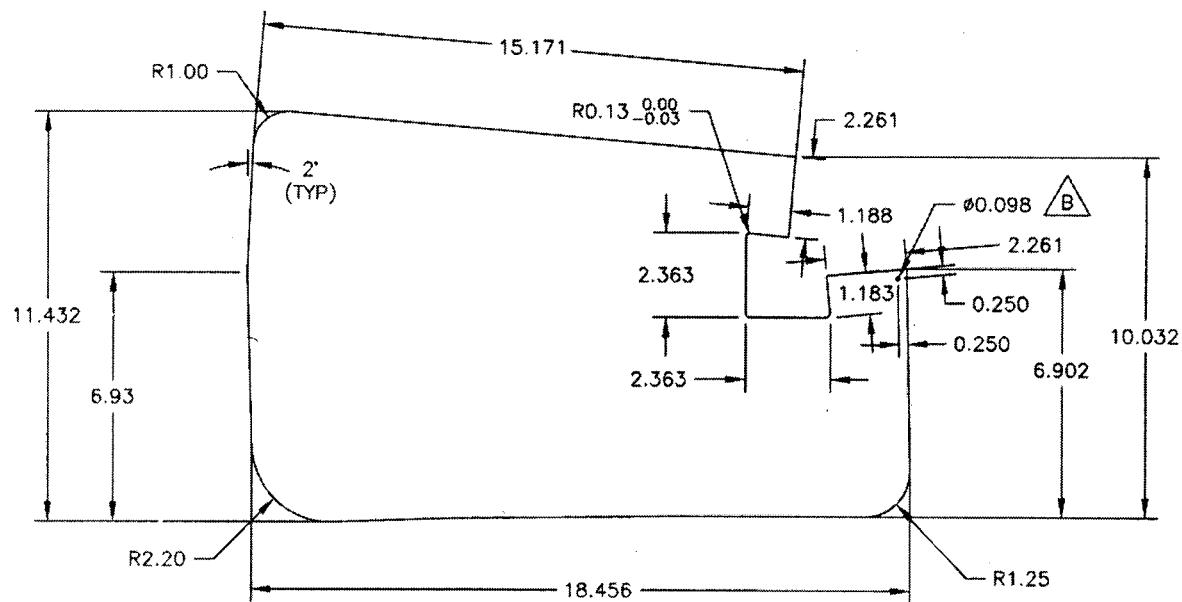
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CHECKED <i>IP</i>	APPROVED <i>HF</i>	DRAWING NO. D3255	REV. B SHEET 3 OF 4
DATE 04.12.06		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:5

RELEASED
05-01-18



D3255-1/-2 FLAT PATTERN

D3255-1/-2 NOTES:

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

05/23/08

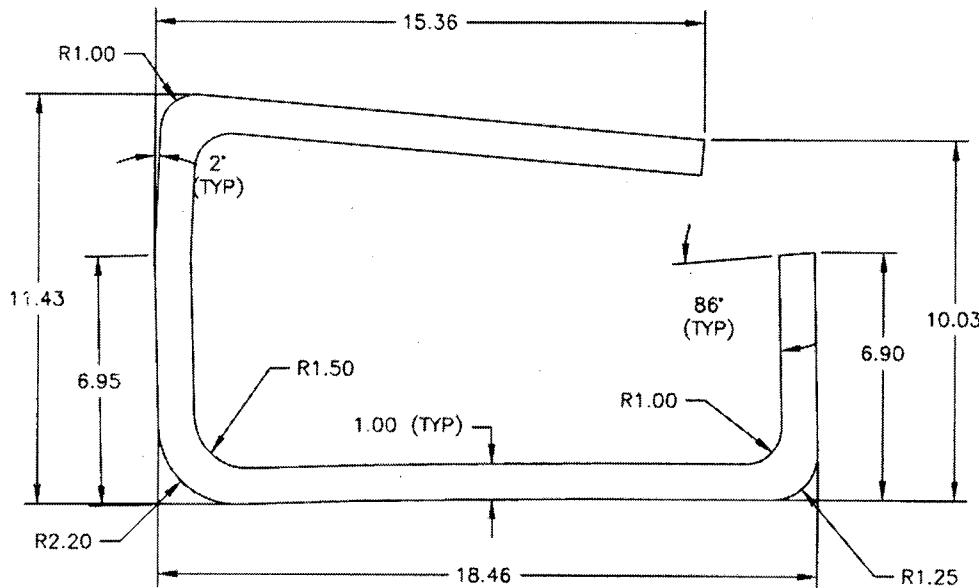
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DESIGN <i>TT</i>	DRAWN BY <i>TT</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>IP</i>	APPROVED <i>TT</i>	DRAWING NO. D3255 REV. B SHEET 4 OF 4
DATE 04.12.06		TITLE ACCESS PANEL ASSEMBLY SCALE 1:5

RELEASED
05.01.18 *TT*

**D3255-5 GASKET****D3255-5 NOTES:**

- 1) MATERIAL: SILICONE COATED FIBERGLASS CLOTH PER AMS 3320F
P/N SIL/F 36x36x1/16
POSSIBLE SUPPLIER: AVIALL
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

5.0 PARTS LIST

Qty -011	Qty -013	Qty -015	Qty -017	Qty -019	Qty -021	Qty -023	Part Number	Description
X							D412-705-011	TWIN PAK E-Z ACCESS KIT
1	X						D412-705-013	INTAKE PLENUM ACCESS PANEL KIT
1		X					D412-705-015	DRIVESHAFT TUNNEL MODIFICATION KIT
1			X				D412-705-017	N1 GEARBOX ACCESS PANEL KIT
1				X			D412-705-019	C-BOX OIL COOLER LINE SUPPORT ACCESS KIT
1					X		D412-705-021	OIL PRESSURE TRANSMITTER ACCESS KIT
1						X	D412-705-023	OIL COOLER SUPPORT REMOVABLE LOWER PANEL KIT
1							D3245-041	ACCESS PANEL ASSEMBLY, LH
1							D3245-042	ACCESS PANEL ASSEMBLY, RH
2							D3245-043	DOOR ASSEMBLY
2							D3245-9	GASKET
2							D3245-11	GASKET
2							D3245-13	GASKET
			1				D3255-041	ACCESS PANEL ASSEMBLY, LH
							D3255-042	ACCESS PANEL ASSEMBLY, RH
							D3256-1	ACCESS PANEL
			1				D3256-3	GASKET
				1			D3259-041	ACCESS PANEL ASSEMBLY, LH
				1			D3259-042	ACCESS PANEL ASSEMBLY, RH
					1		D3307-041	ACCESS PANEL ASSEMBLY
						30	AN3-3A	BOLT
22		30			6		AN3C-3A	BOLT
3							AN3C-4A	BOLT
						30	AN960JD10	WASHER
16	44	36			12		MS20427M3-3	RIVET
						2	MS21051-L3K	NUT PLATE
8	22	18			6		MS21060-L3K	NUT PLATE
						18	MS21069-L3K	NUT PLATE
		25	30		6		MS9321-09	WASHER

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Revision: C
Date: 07.10.12